

D4464-041 FUEL TANK ASSEMBLY

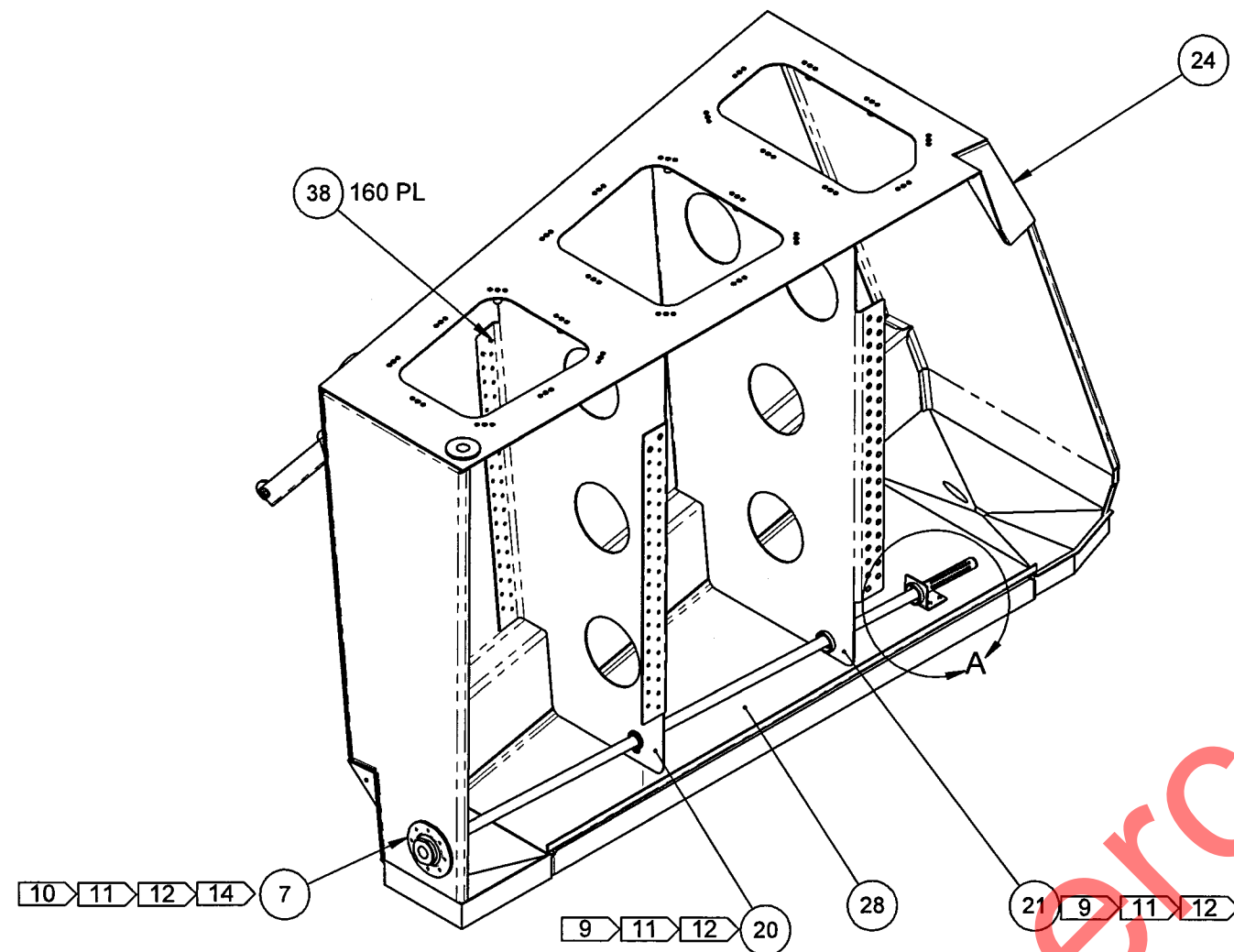
- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: PRIME TEMPO GREY (4.2.1.3.2) PER DART QSI 005 4.2.1
PAINT FLAT GREY (4.2.2.3) PER DART QSI 005 4.2.2
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D350-794-141" USING D2729-1 RED DECAL
 - 7) WEIGHT: 39.71 lbs
 - 8) LPI AND PRESSURE TEST PER DART QSI 038 6.3
 - 9) MASK PRIOR TO FINISH
 - 10) INSTALL AFTER FINISH
 - 11) LOCKWIRE BOLTS AFTER INSTALLATION PER AC 43.13 OR MS33540
 - 12) INSTALL CUSHION USING CONTACT CEMENT. TRIM TO FIT IF REQUIRED
 - 13) INSTALL D4577-041/-1/-3 ACCESS PANELS WET WITH PROSEAL P/S 890B.

UNDER REVIEW
URF 19-834 19-08-01 SAD

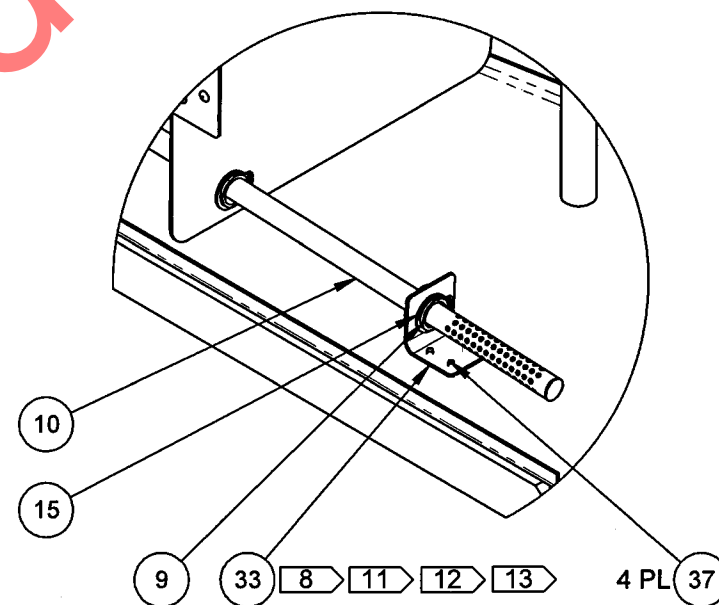
RELEASED
2017-10-06

APPROVED

DESIGN	ML	DART AEROSPACE LTD	
DRAWN	WK	HAWKESBURY, ONTARIO, CANADA	
CHECKED	VS	DRAWING NO.	REV. I
MFG. APPR.	DD	D4464	SHEET 2 OF 5
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	TANK ASSEMBLY	NTS
DATE	17.08.01	<small>COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



D4464-041 FUEL TANK ASSEMBLY
D4463-9 TANK BACK REMOVED
TO SHOW INTERIOR DETAIL



DETAIL A
ROTATED FOR CLARITY
SCALE 2X

NOTES:

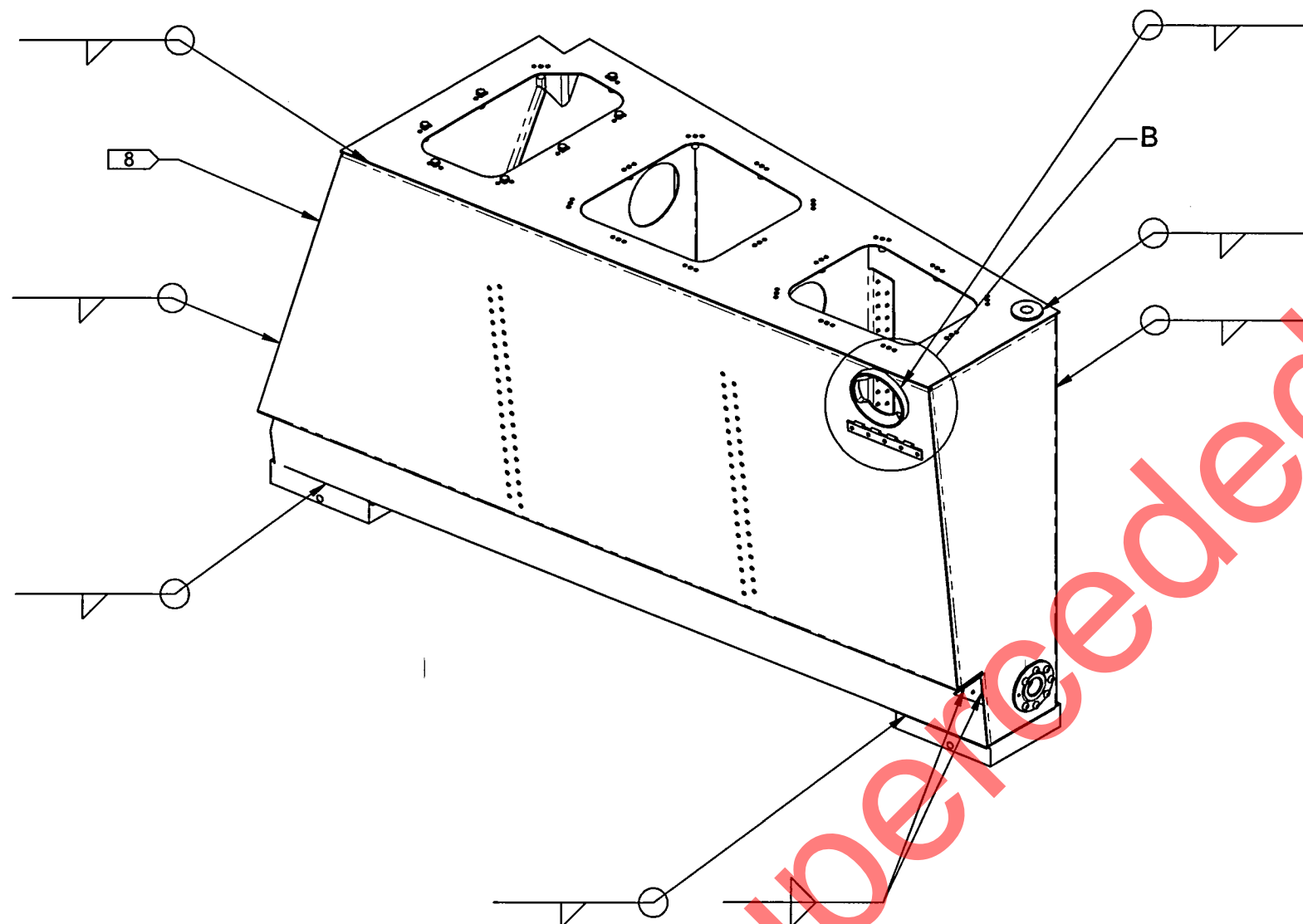
- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) COAT FAYING SURFACES OF D4975-1 ANGLE BRACKET AND D4463-13 TANK BOTTOM WITH PROSEAL P/S 890B AND WET INSTALL MS20426AD4-4 RIVETS
- 9) COAT FAYING SURFACES OF D4462-1/-3 BAFFLES AND D4463-9/-11 TANK FRONT/BACK WITH PROSEAL P/S 890B AND WET INSTALL MS20470AD4-4 RIVETS
- 10) COAT FAYING SURFACES OF D4000-1 FUEL SUPPLY FITTING AND D4463-3 TANK AFT END WITH PROSEAL P/S 890B AND WET INSTALL MS20470AD4-6 RIVETS
- 11) FILLET SEAL THE INTERIOR OF THE TANK AROUND THE EDGE OF D4975-1 ANGLE BRACKET, D4462-1/-3 BAFFLES AND D4000-1 FUEL SUPPLY FITTING WITH PROSEAL P/S 890B
- 12) DOME SEAL ALL BUCKED ENDS OF RIVETS WITH PROSEAL P/S 890B
- 13) TRANSFER DRILL $\varnothing 0.128$ HOLES FROM D4975-1 ANGLE BRACKET INTO D4463-13 TANK BOTTOM AND COUNTERSINK HOLES $\varnothing 0.225 \times 100^\circ$ FROM THE OUTSIDE OF THE TANK
- 14) INSTALL D4000-1 FITTING WITH FLAT FACING UPWARDS
- 15) BRUSH PROSEAL 890A ON ALL INTERNAL SHEET METAL FOLDS

UNDER REVIEW

URF 19-834 19-08-01 SAD

RELEASED
2017-10-06
APPROVED

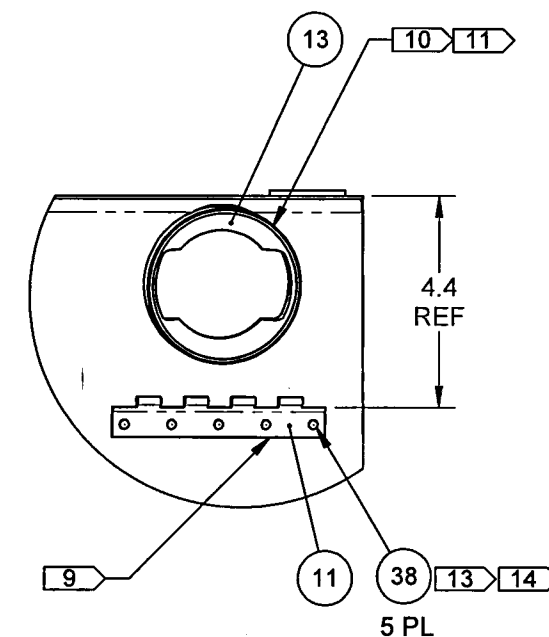
DESIGN	ML	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	WK		
CHECKED	VS	DRAWING NO. D4464	REV. I
MFG. APPR.	DD	SHEET 4 OF 5	
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	TANK ASSEMBLY	NTS
DATE	17.08.01	<small>COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



D4464-041 FUEL TANK ASSEMBLY
WELDING AND RIVETING DETAIL

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) TRIM FLANGES AS REQUIRED TO FIT ASSEMBLY
- 9) CENTER HINGE BELOW FUEL CAP FLANGE
- 10) POSITION FUEL CAP FLANGE AS SHOWN, ELONGATED HOLE APPROXIMATELY HORIZONTAL
- 11) POSITION FUEL CAP FLANGE SO THAT INNER FACE IS FLUSH WITH INSIDE OF TANK
- 12) WELD PER DART QSI 004
- 13) COAT FAYING SURFACES OF D4008-11 TANK HINGE HALF AND D4463-11 TANK FRONT WITH PROSEAL P/S 890B AND WET INSTALL MS20470AD4-4 RIVETS
- 14) DOME SEAL ALL BUCKED ENDS OF RIVETS WITH PROSEAL P/S 890B



DETAIL B
ROTATED FOR CLARITY
SCALE 2X

UNDER REVIEW
URF 19-834 19-08-01 SAD

APPROVED

DESIGN	ML	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	WK		
CHECKED	VS	DRAWING NO. D4464	REV. 1
MFG. APPR.	DD		SHEET 5 OF 5
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	TANK ASSEMBLY	NTS
DATE	17.08.01	<small>COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

Under Review Notification

Raised By: Steven Drouin

Product #: D350-794

Date: 19.08.01

Product Name: AUXILIARY FUEL TANK

Part Number (D-Part and 9-Digit) (eg. D3535-11) (eg. D3535-25) (eg. D206-642-143) (eg. RBEM324U3010101-1)	Drawing or Document & <u>Current</u> Affected Revision for each part listed	"Y" or "N" Required for Each Part Do not leave blank							Reserved ECN / URF Log Number	Instructions Relevant to Each Part (including whether CHG #'s will be affected)
		DO NOT SHIP	Red Tag/Quarantine Stock	Advise Customers	Hold all Production	Re-Work Stock	IPP Under Review (Engineer Signoff Required.)	Put Product Specifications Under Review ("Bluefiles")		
D350-794-141	IIN-D350-794 Rev. H	Y	N	N	Y	N	Y	Y	19-832	CHG#005
D4464-041	D4464 Rev. I	Y	N	N	Y	N	Y	Y	19-832	Update Drawing
D350-794-111	IIN-D350-794 Rev. H	Y	N	N	Y	N	Y	Y	19-832	CHG#007
D4463-9/-11	D4463 Rev D	Y	N	N	Y	N	Y	Y	19-832	Update Drawing

Description of Issue:

One of the panel's Flat pattern (D4463-11) is causing a fit issue with the final assembly

Distribution:

VP Operations	Director of Engineering	Customer Support Manager	Technical Support
Director of Operations	Chief Engineer	Production Engineers	Product Manager - Solutions Provider
Director Quality Assurance	Engineering Project Managers	Production Planners	Supply Chain Director / Senior Buyer
QC Coordinator	Engineering Clerk	Purchasing Manager	Marketing Eugene